

Page 1

Wednesday, September 15, 2010 9:47:41 AM D4164-041 Item ID: Accept Setup Start **Revision ID:** Stop Item Name: Nut Plate Adapter Assembly **Start Oty: 20.00** Start Date: 9/14/2010 Cust Item ID: Req'd Qty: 20.00 Required Date: 9/21/2010 Customer: Reference: Start Run Date J-915 Tooling: Approvals: Date:

Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description Stamp Qty Qty **Run Hours** Code Number Draw Nbr Revision Nbr D4164 Α 100 0.00

Date:

SPC (Y/N):

Waterjet

FLOW CNC Waterjet

6061.040

FLOW WATER JET

0.00 Memo

Prog Rev:

QC2- Inspect parts off machine FAI/FAIB

1-Cut as per Dwg D

Date:_

2-Deburr if necessary

0.00

110 QC

1310-9-14

Stop

132 10-9-15

0.00

Quality Control

Memo

QC8- Inspect parts - second check

120

Quality Control

Memo

	WORK ORDER CHANGES								
STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
			1						
	. 1% .								
	STEP	STEP PROCEDURE CHANGE		STEP PROCEDURE CHANGE By Date	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr			

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:			WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC	Posserintian of NC Corrective Action Section B					Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector				
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Work Order ID 61989

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Item ID:

Wednesday, September 15, 2010 9:47:41 AM D4164-041

Accept



Setup Start



Revision ID:

Item Name:

Nut Plate Adapter Assembly

Start Date:

9/14/2010

Start Oty: 20.00

Reg'd Oty: 20.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan: Date:

Tooling:

Date:

Run

Start

Stop



Required Date: 9/21/2010

SPC (Y/N): Date:

Set Up/

Run Hours

Date:

Tool # Plan

Code

Stop

Reject

Qty

Reject Insp.

Stamp

Number

Sequence ID/ Work Center ID

130

Small Fab

Small Fab

Small Fab

Operation

Description

Memo

1- Deburr 2-C'sink as per Dwg 0.00

0.00

Accept

Otv

140

141

OC

Quality Control

OC5- Inspect part completeness to step on W/O

0.00

Chemical Conversion Coat per QSI005 4.1

=> H 10/09/21

HandFinish Hand Finishing Memo

Memo

0.00

W/O:			WC	ORK ORDER CHAN	GES					,
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	:									
Part No	:	PAR #:	Fault Cate	gory:	NCR	: Yes 1	No DQ	A:	Date:	
	R	esolution:	Dispositio	n:	QA:	N/C Clo	sed:		Date: _	
NCR:	•	1	WORK ORD	ER NON-CONFORM	MANCE	(NCR))			
DATE	CTED	Description of NC			ection B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	1	Sign & Date	Secti		Chief Eng	QC Inspector
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Work Order ID 61989

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Wednesday, September 15, 2010 9:47:41 AM

Item ID:

D4164-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Nut Plate Adapter Assembly

Start Date:

9/14/2010

Start Oty: 20.00 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: Date: Tooling:

Date:

Start

Stop



Required Date: 9/21/2010

Date: _____

SPC (Y/N):

Set Up/

Run Hours

Tool ID

Date:

Run

Reject

Insp.

Sequence ID/ Work Center ID

160

Ouality Control

Operation Description

QC3- Inspect Part Finish

Memo

0.00

10-01-21

Tool # Plan Accept Qty Code

Reject Oty

Number

Stamp

170

Small Fab

Small Fab

Memo

Memo

0.00

0.00

Small Fab

Install Nut plate as per Dwg

180

Quality Control

OC5- Inspect part completeness to step on W/O

Dail Aei	ospace	; Llu							ī
W/O:			WO	RK ORDER CHANGE	S	-	· · · · · ·		,
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						·			
Part No	:	PAR #:	Fault Cate	Jory:	NCR: Yes	No DQ	A:	Date:	
	R	esolution:	Disposition	1:	QA: N/C C	osed:	· · · · · · · · · · · · · · · · · · ·	Date: _	
NCR:			WORK ORDE	R NON-CONFORMAL	NCE (NCF	R)	,		
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	Sign 8	k Sect	cation ion C	Approval Chief Eng	Approval QC Inspector
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Work Order ID 61989

Page 4

Item ID:

Wednesday, September 15, 2010 9:47:41 AM

Accept



Setup Start

Stop



Revision ID:

Item Name:

Nut Plate Adapter Assembly

Start Date:

9/14/2010

D4164-041

Start Qty: 20.00

Req'd Qty: 20.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run



Required Date: 9/21/2010

QC:____

Date:

SPC (Y/N):

Set Up/

Date:

Stop



Sequence ID/

Work Center ID

190

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

Memo



Run Hours

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

200

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

10/09/23 At MF 10-9-23

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W/O:			WC	RK ORDER CHANGE	ES				q
DATE	STEP	PRO	CEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Disposition	ı:	QA: N/C C	losed:		Date: _	
NCR:		\	WORK ORD	ER NON-CONFORMA	NCE (NCF	R)			
		Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Sect	ion C	Chief Eng	QC Inspector
				,					

Picklist Print

Wednesday, September 15, 2010 9:47:45 AM

Work Order ID: 61989

Parent Item:

D4164-041

Parent Item Name: Nut Plate Adapter Assembly



Start Date: 9/14/2010

Required Date: 9/21/2010

Start Oty: 20.00

Required Qty: 20.00

Comments:

IPP REV:A NEW ISSUE 10-09-07 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	86.7300	0.001	0.021053	, 40- 9 -	-15	
5061-T6 .040 Sheet				Location		Loc C	<u>Oty</u>	Loc Code					
				MAT21	113004		6.73 6.73		_	13004			
MS21059L3		Purchased	No				Each	27.0000	1	20	/09/	/21	
				Location ST301	114718	Loc C	<u>Oty</u> 27 27	Loc Code		<u> </u>	111570	08/	92
MS20426AD3-3		Purchased	No		114/10		Each	4,989.000		40	08/2		
					19099 7681	4	2ty 1989 1774 215	Loc Code	-	60		-	

Page 1

W/O:			WC	RK ORDER CHANG	ES				,
DATE	STEP	PRO	CEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	:	Date: _	
	Re	esolution:	Disposition	n:	_ QA: N/C Cld	sed:		Date: _	
NCR:		. V	VORK ORDE	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC	Initial	Corrective Action Section	on B Sign &	Verifica		Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	Date	Section	n C	Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	
Description: NUT PLATE MAPTER ASSEMBLY	Part Number:	D4164-65
Inspection Dwg: 1964-1 Rev:		Page 1 of 1

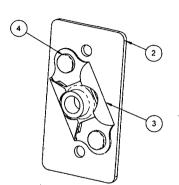
FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype

	rawing mension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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Mazeu	red by:		Audited by:	8	Prototype Ap	proval:	N/A
WEASU	Date:	10-9-14	Date:	100017		Date:	N/A
					Re	vised by	Approved
Rev	Date	Change	-01_{\circ}	1111 CL 1011	KJ	I/JLM	·
Α		New Issue	Y/0 1	14164-04	1.00		1

	- 1		
ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	х	D4164-041	NUT PLATE ADAPTER ASSEMBLY
2	1	D4164-1	NUT PLATE ADAPTER
3	1	MS21059L3	NUT PLATE
4	2	MS20426AD3-3	RIVET



SUBJECT 10. E. S \mathbf{v}_{ABB}

D4164-041 NUT PLATE ADAPTER ASSY

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NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4164-041" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.006 lbs

Α	NEW IS	SUE	RF	10.07.22			
REV.			DESCRIPTION	BY	DATE		
DESIG	N	KB	DART AEROS	PACE L	TD		
DRAW	N	RF	HAWKESBURY, ONTARIO, CANADA				
		85	DRAWING NO.		REV. A		
MFG. APPR.		9/	D4164		SHEET 1 OF 2		
APPRO	VED	-	TITLE		SCALE		
DE APPR.			NUT PLATE ADAPTER ASSY NTS				
DATE 10.07.22			THIS DOCUMENT OF PURPOSE ON CORRESPONDING THE STREET OF THE STREET CONTROL THAT IT IS NOT TO BE USED FOR ANY PURPOSE ON CORRESPONDING THE STREET OF ANY CHIEF PERSON WITHOUT				

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W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PRO	ROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	!								

Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
		esolution:	Disposition	n:	_ QA: N/C Clo	sed:	Date:		
NCR:		\	WORK ORDE	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC	Corrective Action Section B			Verification		Approval	Approval
DAIE		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector
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Ø0.098 2 PL Ø0.098 CSK Ø0.174 x 100° 2 PL R0.06 TYP Ø0.250 -0.875 1.30 0.438 0.65 0.344 0.688 0.35 TYP 0.040 REF 0.18 TYP 0.35 w/041989 0.70 **D4164-1 NUT PLATE ADAPTER**

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С

В

NOTES:
1) MATERIAL:6061T6/T62 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
PER DART SPEC. M6061T6S.040
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP, EDGES: 0.005 TO 0.010 MAY

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: N/A 7) WEIGHT: 0.003 lbs

DESIGN	KB	DART AEROSPACE LTD			
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA			
CHECKED		DRAWING NO.	REV. A		
MFG. APPR.	all.	D4164 SHEET	2 OF 2		
APPROVED	4	TITLE	SCALE		
DE APPR.	-#	NUT PLATE ADAPTER ASSY	NTS		
DATE 10.0	7.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS HERVET IN NO COMPENENTIAL AND IS UMPILED ON THE CEPTES O DOCUMENT THAT IT IS HOT TO BE USED FOR ANY PURPOSE OR COMPENSATE TO TAM OTHER PERSON WITHOUT			

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W/O:			WC	RK ORDER CHANGE	S			
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA :	Date: _	
			Disposition: QA					
NCR:		\	WORK ORD	ER NON-CONFORMAI	NCE (NCR)		
DATE	STEP	Description of NC	Corrective Action Section B			Verificat		Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	C Chief Eng	QC Inspector
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